

Date: Friday, 7/27/2007 1:15:51 PM  
User: Kim Johnston

## Process Sheet

32

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 33761		
Estimate Number	: 12788		
P.O. Number	: N/A	Part Number	: D356413
This Issue	: 7/27/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3564 REVC
First Issue	: N/A	Project Number	: N/A
Previous Run	: 33456	Drawing Revision	: C
		Material	: N/A
		Due Date	: 8/8/2007
Written By	:	Qty:	22 Um: Each
Checked & Approved By	: <u>07.07.29</u>		
Comment	: Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.1785 sf(s)/Unit Total: 3.5700 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: M101873

B01-07-30

07/07/29

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3564

Dwg Rev: C

Prog Rev: C

B 07-07-30

2-Debur if necessary

SAD

07/07/30 (22)

SAD 07/07/29

22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/07/29

22

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 07/07/30

(22)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Debur if necessary

Form on Brake as per Dwg D3564 using Jigs DT and DT

FF 07-08-08

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 07/08/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/27/2007 1:15:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 33761

Part Number: D356413

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

Counted  
Er 07/08/08 (422)

7.0

POWDER COATING

POWDER COATING



M104846



(22x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

mrl 07/08/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PP-17

BR

07-08-10

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(22)

Comment: FINAL INSPECTION/W/O RELEASE

PP 07/08/10

Job Completion



CL 07/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

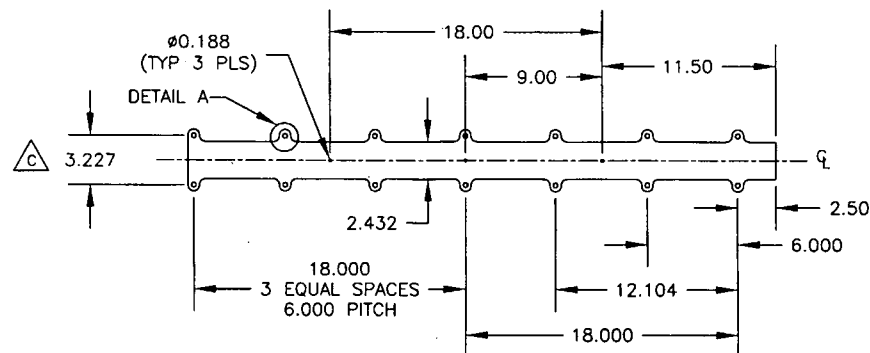
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

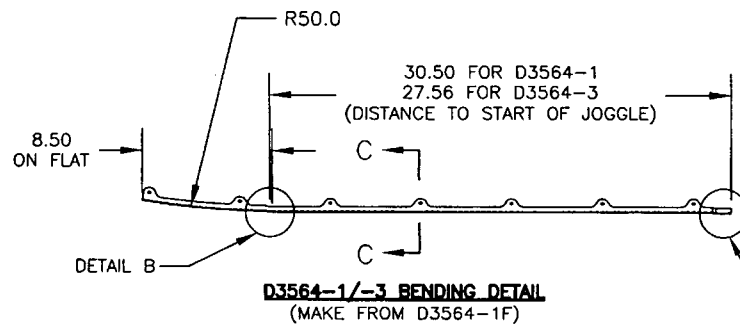
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

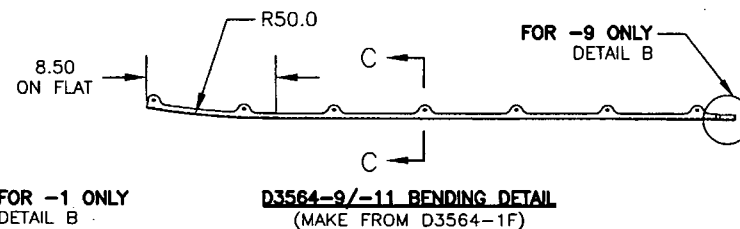




**D3564-1F FLAT PATTERN**



**D3564-1/-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-9/-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



**D3564-1/-3/-9/-11 WELDING DETAIL**

**RELEASED**  
07.06.28

**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

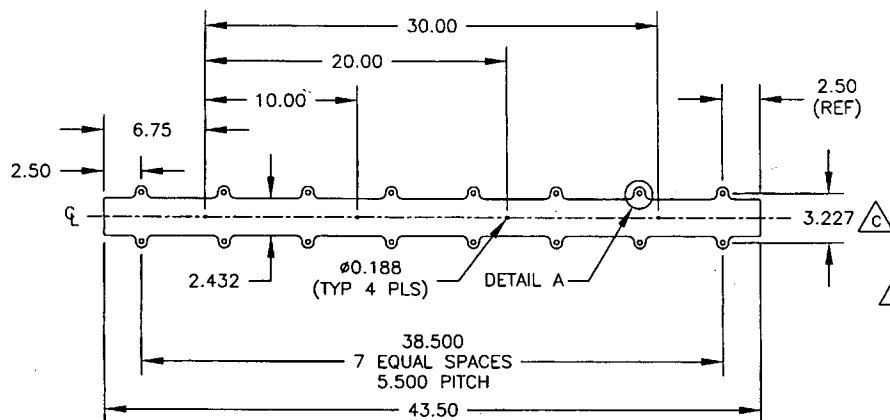
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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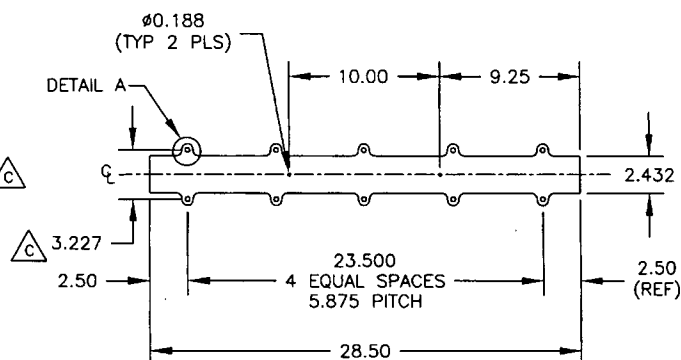
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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3564
DATE 07.04.17	TITLE WEARSHOE	REV. C SHEET 1 OF 2 SCALE 1:8

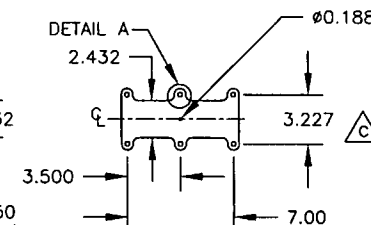
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WORK ORDER  
NO 33761



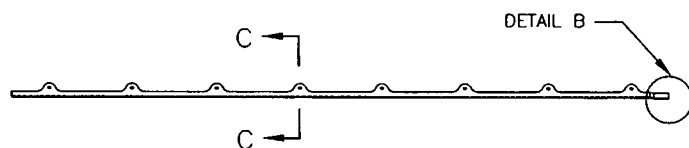
**D3564-5F FLAT PATTERN**



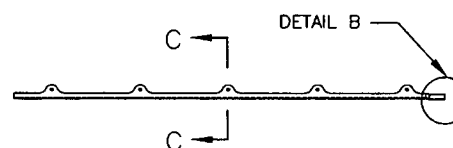
**D3564-7F FLAT PATTERN**



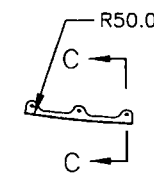
**D3564-13F FLAT PATTERN**



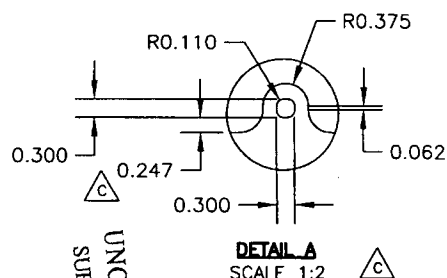
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



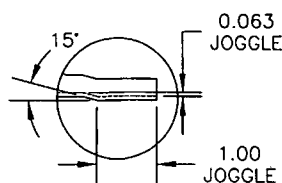
**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



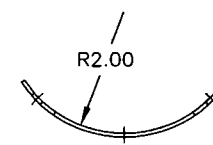
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**DETAIL A**  
SCALE 1:2



**DETAIL B**  
SCALE 1:2



**SECTION C-C**  
SCALE 1:2

**RELEASED**  
07.04.17

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DATE		07.04.17		DRAWING NO.	REV. C
				D3564	SHEET 2 OF 2
				TITLE	SCALE
				WEARSHOE	1:8